

# Work Order ID 52792

October 14, 2009 10:44:42 AM



Page 1

Item ID: D3391-023

Accept



Setup Start



Revision ID: H

Stop



Item Name: Mid Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

*PS*

Date:

*09-10-14*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	Rev H								

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

4-Open saddles and GHW holes to Ø0.375" except for fwd saddle hole of detail "J"

5-Remove .030" from Fwd indexing Ridge as per Dwg D3391

6-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

7-Deburr

8-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

9-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J"

10-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391

*09-10-16*

*AWM 9-10-22*

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Item Name: Mid Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

11-Open .375" holes to .438" \*\*\*do not open fwd saddle holes\*\*\*

-Awm 9-10-22

12-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

13- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer drilled pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021

14- Transfer drill 2 wearplate holes into D3391-021 using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.

15- Locating from two fwd wearplate holes drilol remaining 6 wearplte holes in D3391-021 using DT8937

16- Open 2 fwd wearplate holes in D3391-023 to .250" dia.

17- counterbore two aft wearplate holes in D3391-021 as per dwg

18- Open 12 wearplate holes in D3391-021 to 0.297" dia.

19-Deburr and blow out all chips from inside tube

1 k 9/10/27

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Item ID: D3391-023

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Revision ID: H

Item Name: Mid Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00

Required Date: 02/11/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

278 02/10/27

⑩

/

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1

H 9/10/27

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

⑪

BE 09/10/27

**Work Order ID 52792**

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Item ID: D3391-023

Accept

Revision ID: H

Item Name: Mid Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00

Required Date: 02/11/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140



Skidtubes

Skidtubes

Skidtubes

Memo

1-Open float bag holes as per dwg  
2-C'sink float bag holes as per dwg  
3- Prepare tube for welding  
4-Bond web in place as per Dwg D3391 & QSI 015.  
Adhere for 12 hours)

0.00

0.00

12# M 112397

Ex2 10/2/20

1 11/10/27

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2) 8 09/10/28

(40) 6

160



Skidtubes

Skidtubes

Skidtubes

Memo

1-Weld crossbolt spacer as per dwg D3391 & QSI 004  
2-grind weld flush

AIR M111989

0.00

0.00






DP 9-10-28



(11) 09/10/28




# Work Order ID 52792

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Item ID:	D3391-023	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	Mid Tube Assembly					
Start Date:	14/10/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	02/11/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00 0.00	⇒ Sorkobg			(X)	9		
180  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	⇒ Sorkobg			(X)	9		
190  Powdercoat Powder Coating	<p>EXPRESSURE - WASH</p> <p>White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum</p> <p>1112140</p> <p>START TIME: 8:45am</p> <p>OVEN TEMPERATURE: 320°F</p> <p>FINISH TIME: 9:15am</p>	0.00 0.00	⇒ HP 09/10/29			(X)			

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Item ID: D3391-023

Accept



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Revision ID: H

Stop



Item Name: Mid Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MD 09/10/29 XI

210

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

MD 09/10/30

XI

1- insert D3391-021 into D3391-23

2- insert T-pins into first and third fwd saddle holes

3- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per DSI 9364

4- remove T-pins and locate DT9415 from first and third crossbolt hole using T-pins and clekos

5- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". Remove DT9415

6- deburr, re-alodine and blow out chips

7- press fit D3591-1 spacers using DT9416 starting from 0.500" side

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Item ID: D3391-023

Accept



Setup Start



Revision ID: H

Stop



Item Name: Mid Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop










Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	⇒ Serials			④			
230  HandFinish Hand Finishing	HandFinishing  Memo Install Inserts as per Dwg	0.00  0.00	mo 09/10/30			X1			
240  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	⇒ Serials			④	φ		




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Item ID: D3391-023 Accept  Setup Start   
Revision ID: H Stop   
Item Name: Mid Tube Assembly  
Start Date: 14/10/2009 Start Qty: 1.00  Cust Item ID:  
Required Date: 02/11/2009 Req'd Qty: 1.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo <i>U/O 52783</i>	0.00  0.00	<i>U/O</i>	<i>09/11/03</i>		<i>21</i>			
260  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<i>09/11/03</i>  <i>MF 09-11-03</i>



# Picklist Print

October 14, 2009 10:44:50 AM

Page 1

Work Order ID: 52792

Parent Item: D3391-023RevH

Parent Item Name: Mid Tube Assembly

Comments:

Start Date: 14/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-1-100RevU/R		Manufactured	No			100	Each	0.0000	1.0000			
Skidtube Extrusion												
D3391-021RevH		Manufactured	No			100	Each	0.0000	1.0000			
Fwd Tube Assembly												
D3389-1RevD		Manufactured	No			140	Each	9.0000	1.0000			
Web												

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

9

47303

1

48244

1

48245

1

48246

1

48247

1

50226

4

11/9/10/27

# Picklist Print

Page 2

October 14, 2009 10:44:50 AM

Work Order ID: 52792



Parent Item: D3391-023RevH



Parent Item Name: Mid Tube Assembly

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3681-1RevA		Manufactured	No			160	Each	89.0000	5.0000			
Spacer												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

LG    20

51920    20

Main Warehouse

ST    69

47123    13

48178    56

5 BE 09/10/28

D3591-1RevB

Manufactured No

210

Each

73.0000

2.0000



Bushing

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    73

46105    29

47121    44

12 mp 09/10/30

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Shop Packet Print

Page 2

# Picklist Print

Page 3

October 14, 2009 10:44:50 AM

Work Order ID: 52792



Parent Item: D3391-023RevH



Parent Item Name: Mid Tube Assembly

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			230	Each	5,373.000	22.0000			



Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5373	
110511	5373	

220 MD 09/16/30

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

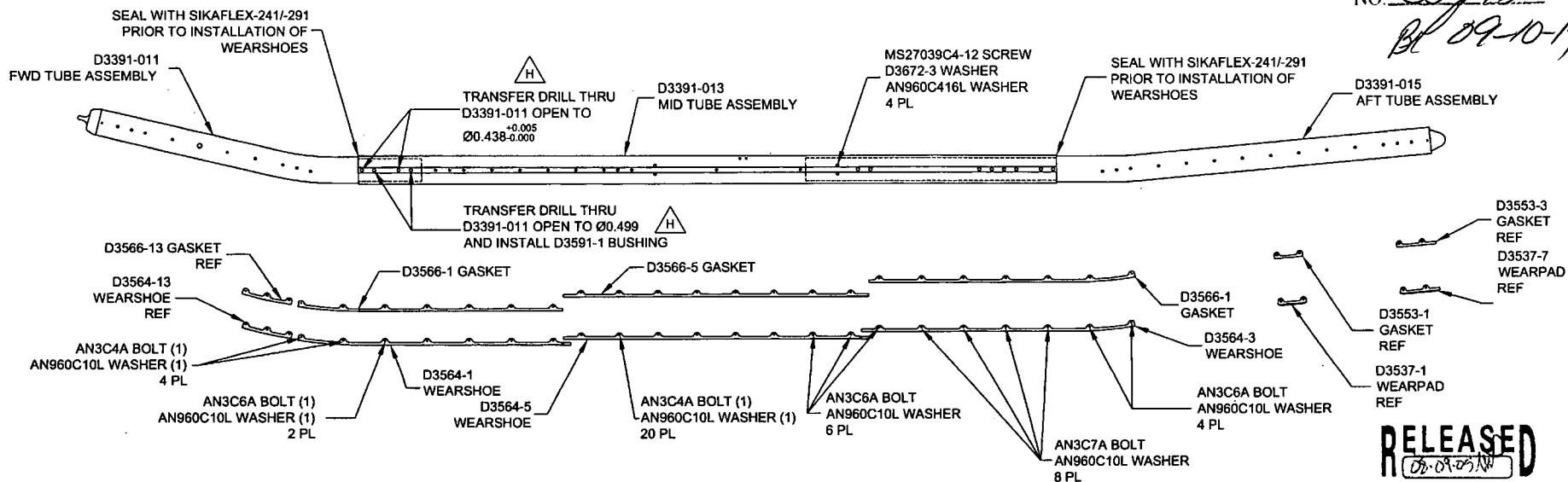
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 52772

09-10-14



D3391-041 ASSEMBLY

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

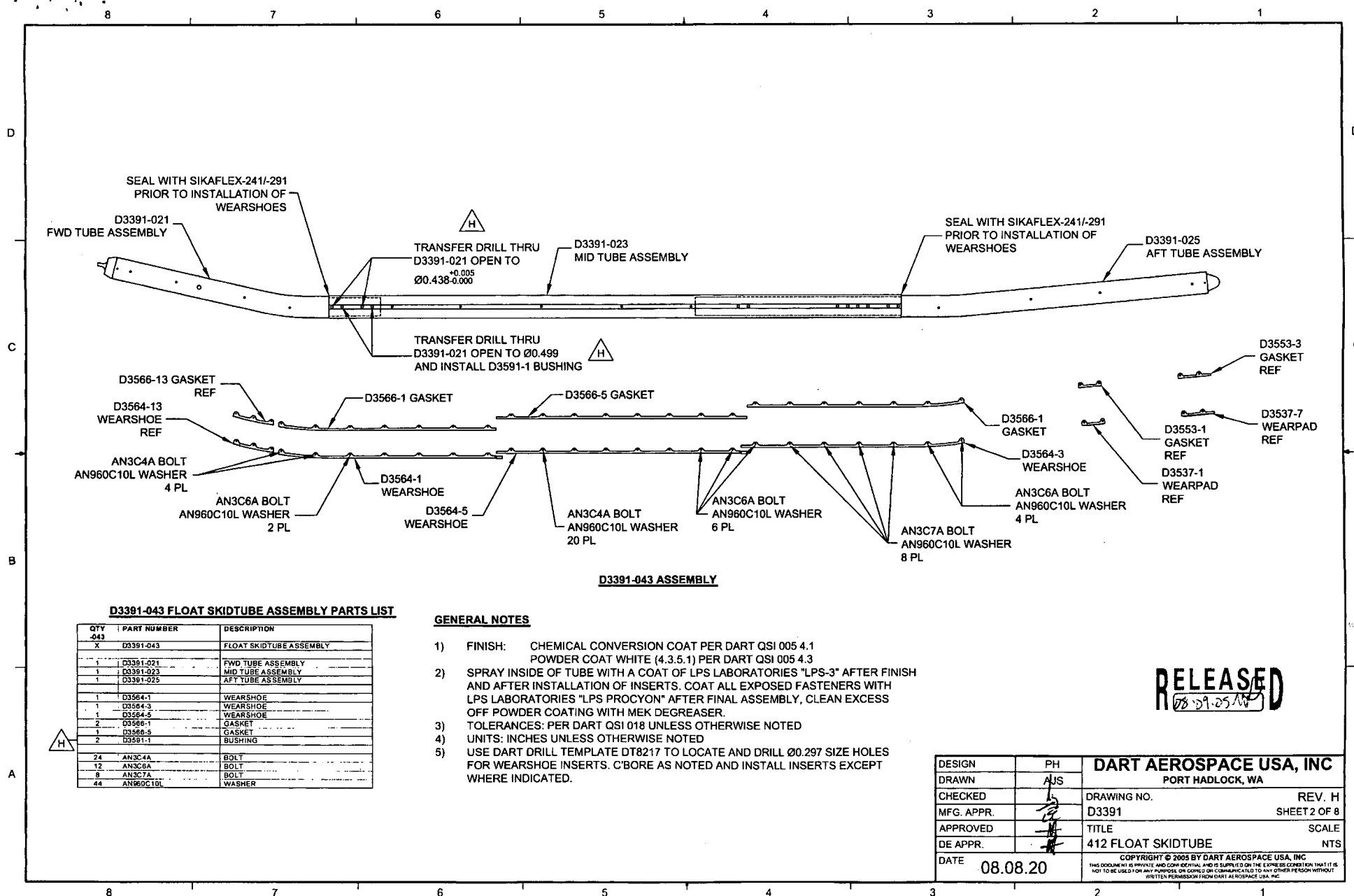
QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-5	WEARSHOE
1	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
2	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
6	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

## GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH  
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH  
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS  
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 SIZE HOLES  
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 0.438 DIM WAS 4 PL. ADDED 0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 0.438 DIM WAS 4 PL. ADDED 0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/0 52792



**D3391-043 ASSEMBLY**

**D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3561-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

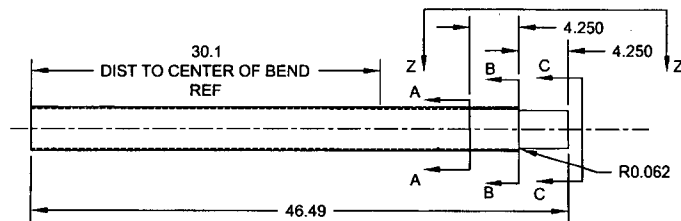
**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

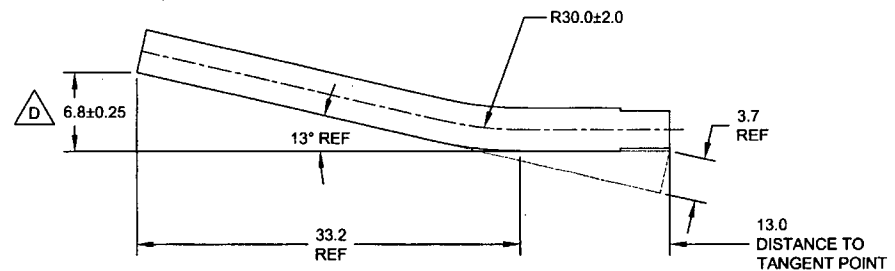
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08-09-25

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CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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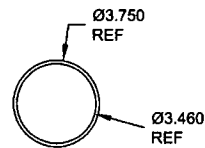
W/052792



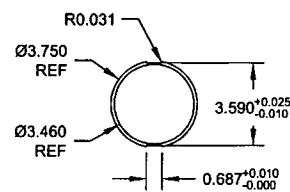
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



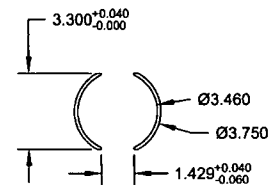
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



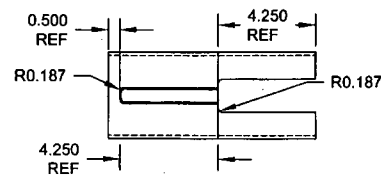
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**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X

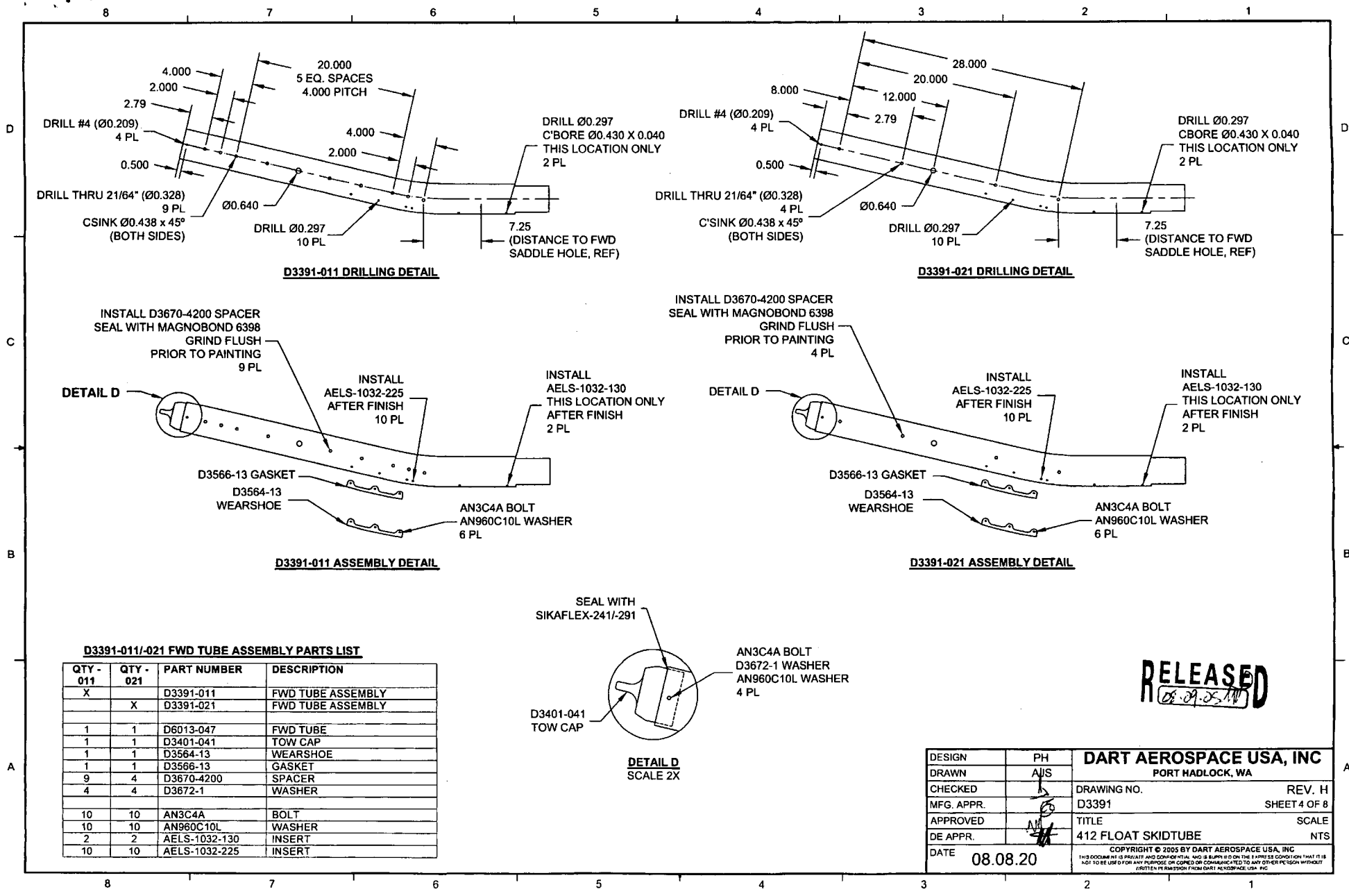


**VIEW Z-Z**  
SCALE 2X

**RELEASED**  
08-05-11

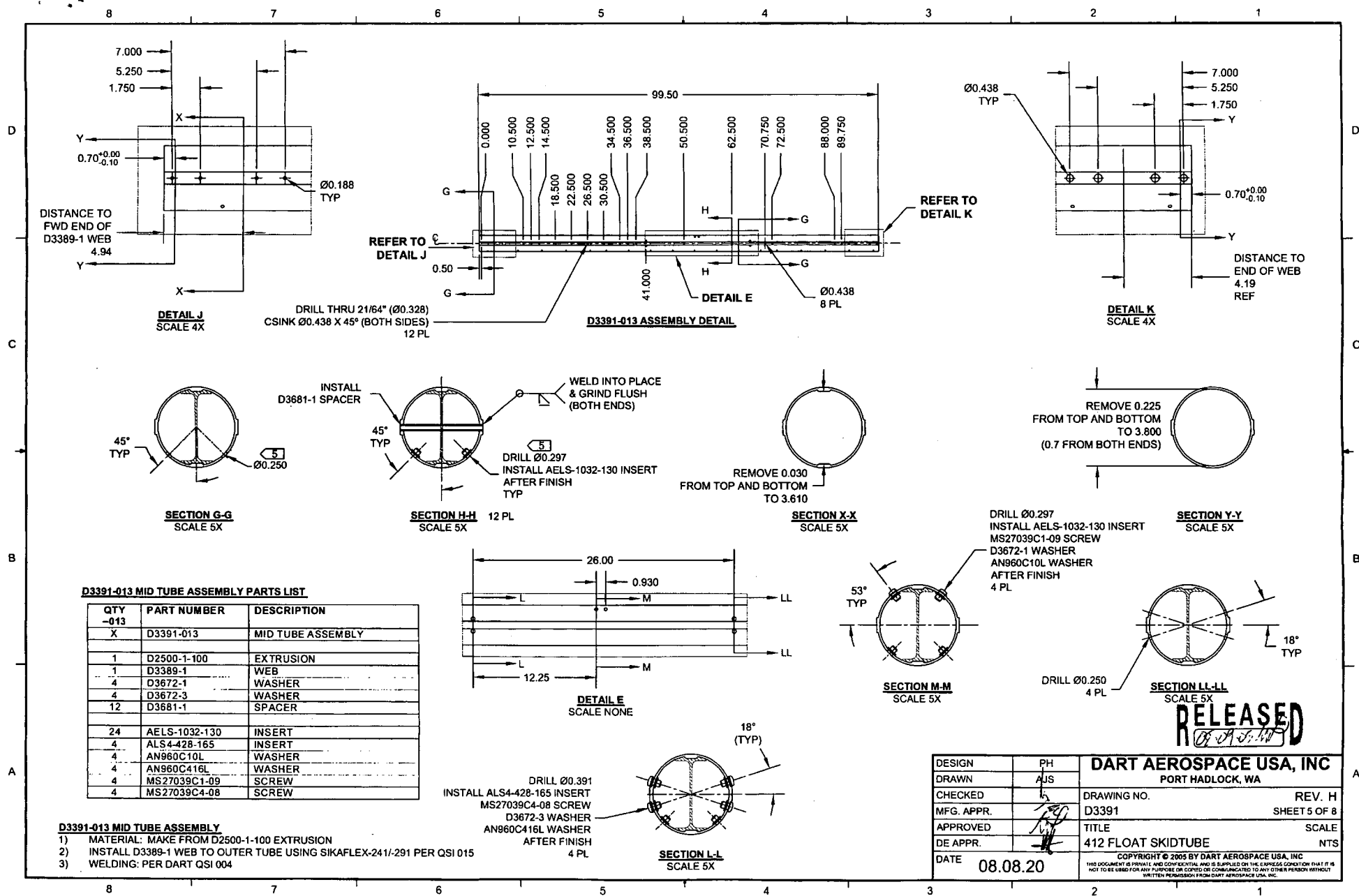
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
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DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 4 OF 8
APPROVED		TITLE	SCALE
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w/o 52792



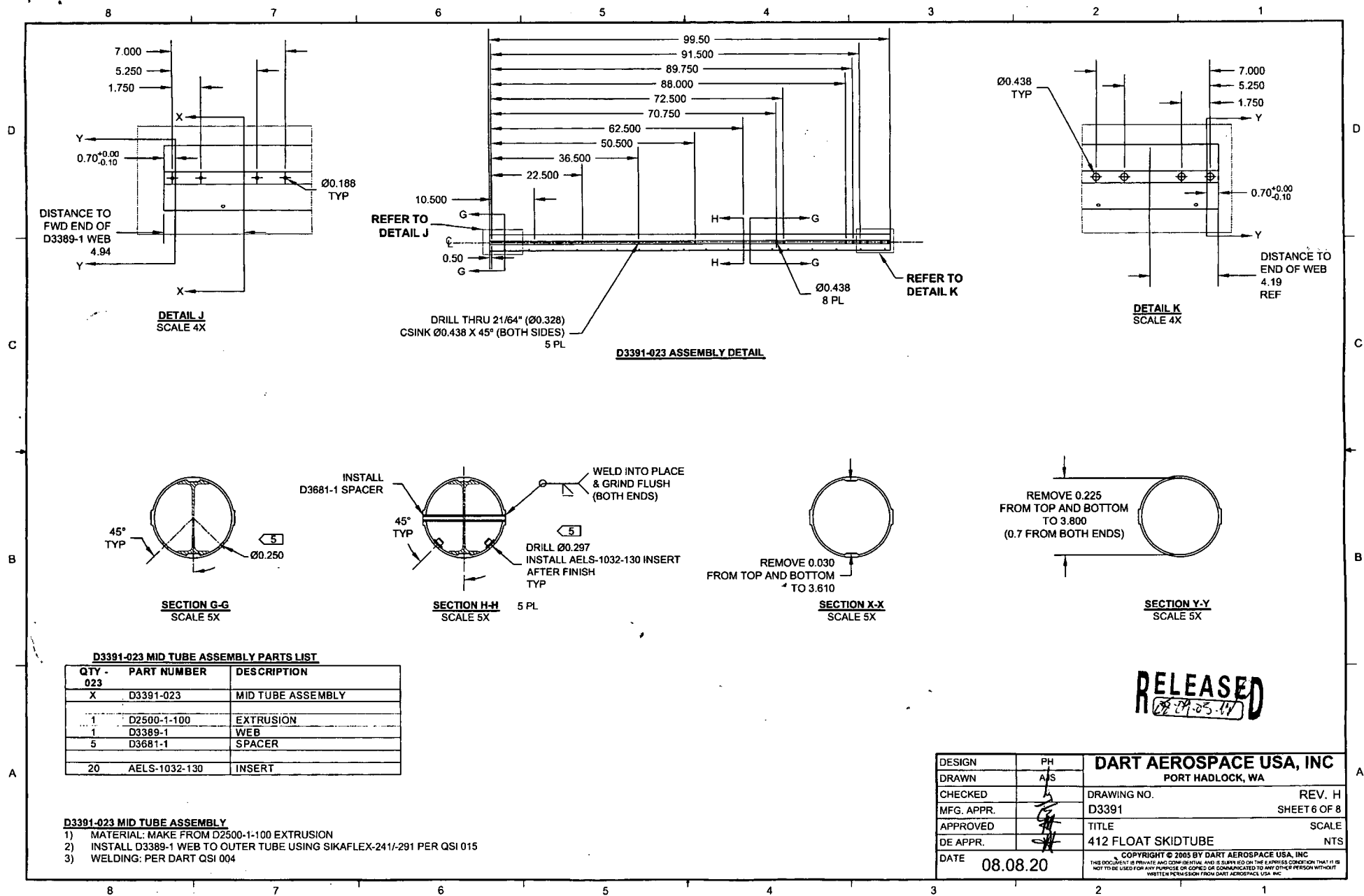
RELEASED

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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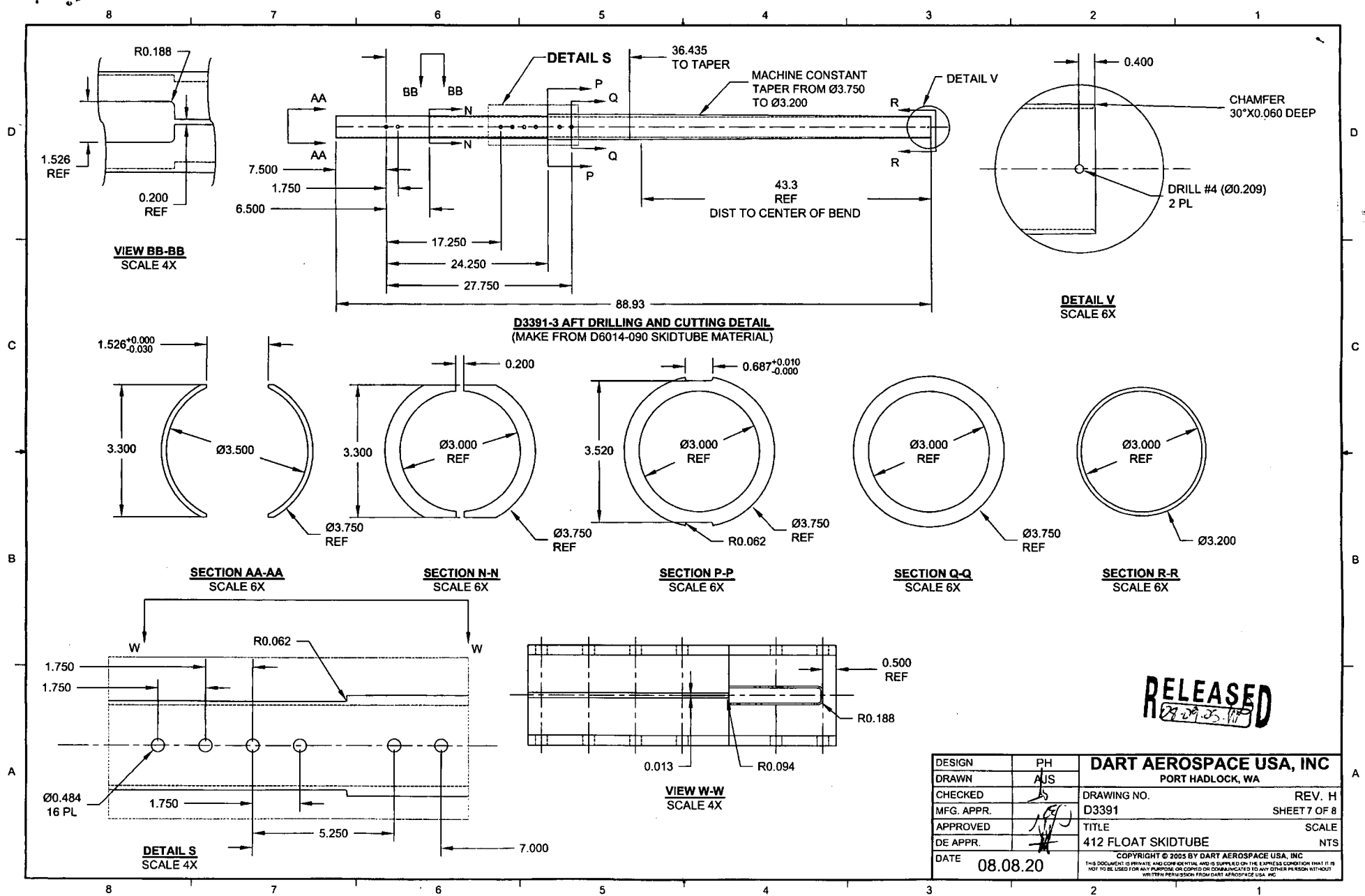




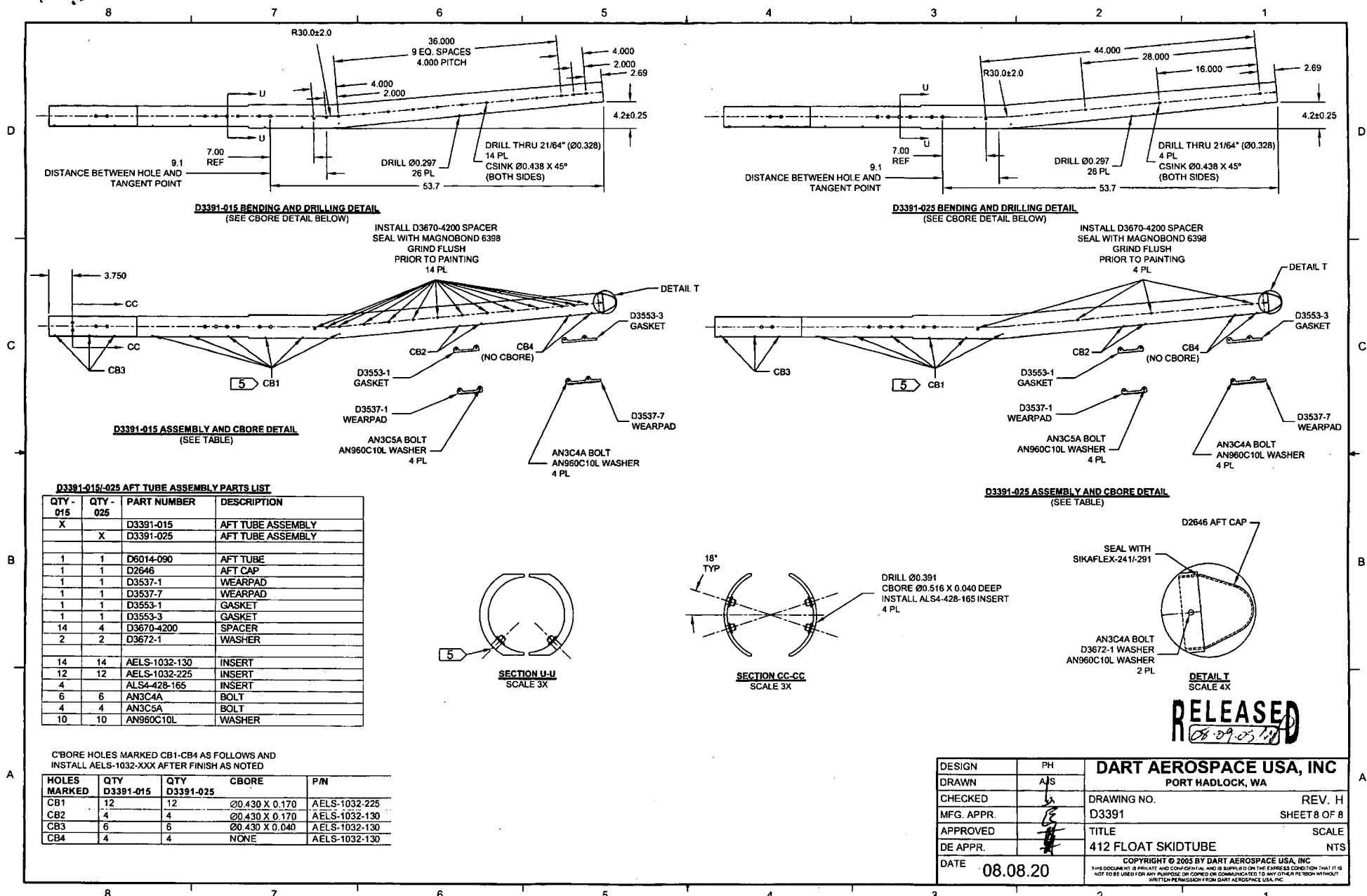
W/0 52792



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W/O 52792



DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED	6	DRAWING NO.	REV. H
MFG. APPR.	B	D3391	SHEET 8 OF 8
APPROVED	4	TITLE	SCALE
DE APPR.	4	412 FLOAT SKIDTUBE	NTS
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NO. 200

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 48035  
Part number: D3391023  
Description: Mid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:  
Penetration:

pass[☒] fail[ ]  
pass[☒] fail[ ]

UNACCEPTABLE

Cracks:  
Undercut:  
Pin holes:  
Overlap (cold lap)  
Porosity (surface):  
Coloration:

pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]

Qualifier Vol. D

Date of Test Coupon 09-06-01

Welder Barclay Elliott

Date of Test Coupon 09-06-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld